

Work Order ID 73515

Thursday, September 01, 2011 12:44:25 PM

Page 1

Item ID: D3969-3

Accept

Setup Start

Revision ID:

Stop

Item Name: Spring (Basket Lid)

Start Date: 9/1/2011 Start Qty: 30.00

Required Date: 9/1/2011 Req'd Qty: 30.00

Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr D3969	Revision Nbr C								
100		0.00							
Purchasing									
Purchasing	Memo Issue P/O: 14805 Order as per Dwg D3969 Possible supplier: LS Technologies part#: SSA4/8-122-310-360N Material release note is required	0.00							
116	Receive & Inspect for Damage & Mat'l Certs	0.00							
Packaging									
Packaging	Memo	0.00							

CL 11/09/01 30

P 11/9/11 (30)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Page 2

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Item Name: Spring (Basket Lid)

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Cust Item ID:

Required Date: 9/1/2011 Req'd Qty: 30.00



Customer:

Reference:

Run Start



Approvals: Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

120

QC6- Inspect dimensions to drawing

0.00



QC

Memo

0.00

Quality Control

130

Identify as per dwg & Stock Location: *81270*

0.00



Packaging

Memo

0.00

Packaging

140

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/09/08

SP

30

SP 11-09-08

11/9/12

MF 11-09-08

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

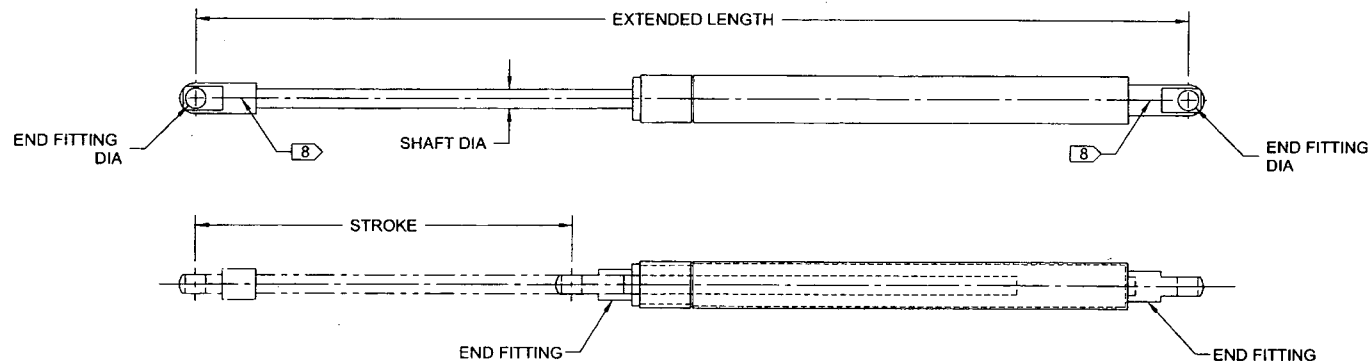
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SPECIFICATION CONTROL DRAWING



D3969-X SPRING

DART PART NUMBER	STROKE (mm/in)	EXTENDED LENGTH (mm/in)	SHAFT DIA (mm/in)	FORCE (N/lbs)	END FITTING TYPE	END FITTING DIA (in)	CASING MATERIAL	PREFERED SUPPLIER	SUPPLIER PART NUMBER	WEIGHT APPROX
D3969-1	120/4.70	315/12.40	6/0.24	310/69.7	BLADE	0.257	STAINLESS STEEL	LS TECHNOLOGIES	SSA4/6-122-315-310N	0.27 lbs
D3969-3	120/4.70	315/12.40	8/0.31	360/80.9	BLADE	0.257	STAINLESS STEEL	LS TECHNOLOGIES	SSA4/8-122-310-360N	0.32 lbs
D3969-5	120/4.70	315/12.40	6/0.24	133/29.7	BLADE	0.257	STAINLESS STEEL	LS TECHNOLOGIES	SSA4/6-122-315-133N	0.27 lbs

RELEASED
2010-03-12
MD

NOTES:

- 1) MATERIAL: SEE CHART
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3969-X" AND B/N USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: SEE CHART
- 8) CRIMP END FITTING AT APPROXIMATE LOCATION SHOWN, PER MANUFACTURERS REQUIREMENTS

W/1073515

C	REDRAWN IN SW. ADDED -3 & -5; ADDED SHAFT DIA COLUMN TO CHART. FORCE FOR -1 CORRECTED (WAS 60.0 lbs).	JPH	10.03.04
B	DRAWING RENAMED WAS: GAS SPRING (BASKET LID). NOTE 8 ADDED.	AJS	09.11.10
A	NEW ISSUE	AJS	09.07.27
REV.	DESCRIPTION	BY	DATE
DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. C
MFG. APPR.	N/A	D3969	SHEET 1 OF 1
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	BASKET LID SPRING	NTS
DATE	10.03.04	COPYRIGHT © 2009 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

W/O:		WORK ORDER CHANGES					
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NOTE: Date & initial all entries



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PO REPRINT

Purchase Order ID PO14805

Purchase Order Date 9/1/2011

PO Print Date 9/1/2011

Page Number 2 of 2

Order From :

VC-LST0001

LS TECHNOLOGIES INC.
303-103 STREET
SASKATOON, SK S7N 1Y9
CA

Contact Name

Vendor Phone 306 683 5000

Vendor Fax 306 683 6403

Vendor Account Nbr

Buyer

Chantal Lavoie

Requisition Nbr

Tax Resale Nbr 10127-2607

Terms

Net 30

Currency

CAD

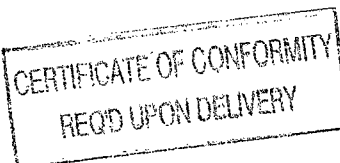
FOB

Destination-Collect

5	SSA4/8-122-310-360N	Gas Spring	9/7/2011	30.00	FedEx PI collect	\$65.0000	\$1,950.00
			Yes	Each			

Special Inst: AS PER DWG D3669 REV. C
B73515

PO Total: \$4,304.20



Change Nbr: 2

Change Date: 9/1/2011

No substitution or deviation without consent.
Certificate of Conformity or Material Certification required when applicable

303 - 103 Street
Saskatoon, SK Canada
S7N 1Y9

Date	Invoice #
9/6/2011	7653

Name / Address
Dart Aerospace Ltd 1270 Aberdeen St. Hawkesbury, ON K6A 1K7

Ship To
Main Finished Goods Location Dart Aerospace Ltd 1270 Aberdeen St. Hawkesbury, ON K6A 1K7

P.O. No.	Ship	Via	FOB	Project
PO14805	9/2/2011	Fed-Ex		

Qty	Description
12	B8-220-530-070N Gas Spring (D3552 Rev H)
16	B6-220-530-140N Gas Spring (D3552 Rev H)
20	BS104 - 10mm Ball Stud Zinc 5/16-18 Thd .75" Lg with Locknut
20	SSA4/6-122-315-310N Stainless Gas Spring (D3969 Rev C)
30	SSA4/8-122-310-360N Stainless Gas Spring (D3969 Rev C)
	Shipping Via FED EX Tracking #795153667815



302-103rd Street, Saskatoon, Saskatchewan, Canada S7N 1Y9
Ph: (306) 683-5000 Fax: (306) 683-6403

Certificate of Compliance

This is to certify that the parts listed below meets specifications as required by your order.

12 Units: B8-220-530-070N Gas Spring (D3552 Rev H)
16 Units: B6-220-530-140N Gas Spring (D3552 Rev H)
20 Units: BS104 - 10mm Ball Stud Zinc 5/16-18 Thd .75" Lg with Locknut
20 Units: SSA4/6-122-315-310N Stainless Gas Spring (D3969 Rev C)
30 Units: SSA4/8-122-310-360N Stainless Gas Spring (D3969 Rev C)

8 11/07/08
Country of Manufacture: Canada
Date of Manufacture : September 2011
This product is ROHS compliant.

We certify no mercury was used in the manufacture of this order.

Purchase Order # 14805
Invoice # 76553

L S Technologies Inc Canada

Mark Ingram
Manager